

Work Order ID 98222

98222

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Item ID: D2873-045 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Nut Plate Assembly
 Start Date: 3/11/13 Start Qty: 40.00 *40* Cust Item ID:
 Required Date: 3/15/13 Req'd Qty: 40.00 *40* Customer:
 Reference:

Approvals: Process Plan: U Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2873	Rev A								
100	BAND SAW	0.00							
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks: 1.000" x 0.375" x 2.700" long								
110	HAAS CNC VERTICAL MACHINING #1	0.00							
110									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per Folio FA and Dwg D2873 Identify as D2873-5 Dwg Rev <u>A</u> F1819Folio Rev <u>AA</u>								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									

mk 13/03/18

40 0

B.A 13/03/19

40 0

DAS
08
9-89

B.A 13/03/19

40 0

DAS
08
9-89

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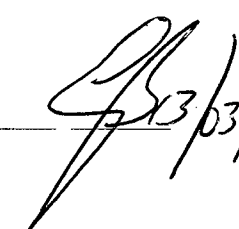

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				40	—		 13.43.20
140 *140* Small Fab Small Fab	Small Fab Memo 1-Deburr 2- C'sink as per Dwg D2873	0.00 0.00				40x	—		
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				40 0045	—		 13.3.22

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160									
HandFinish	Memo	0.00							
Hand Finishing									
170	QC Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	Small Fab	0.00							
180									
Small Fab	Memo	0.00							
Small Fab	1-Assemble as per Dwg D2873 2-Identify as D2873-045								

40 7/5 133.25

40x


3/13/13

40x

3/13/13

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ML5 13-03-26

Picklist Print

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Work Order ID: 98222

Parent Item: D2873-045

Parent Item Name: Nut Plate Assembly

Start Date: 3/11/13

Required Date: 3/15/13

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.375X01.000 6061T6 BAR .375 x 1.00		Purchased	No			180	f	80.0000	0.225	9.4736842			

Location Loc Qty Loc Code

MAT002 80
124573 80

MS20426AD4-6 Rivet		Purchased	No			180	Each	4,372.0000	4	160			
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Location Loc Qty Loc Code

GA 715
122814 715
ST334 3657
121708 57
124392 3600

MS21075L5 Nut Plate		Purchased	No			100	Each	214.0000	2	80			
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Location Loc Qty Loc Code

ST318 214
123346 16
124777 198

9.5 and 13/03/18
160 13/03/20
160 13/03/20
80 13/03/20
2 78

DART AEROSPACE LTD		Work Order: 48222
Description: Radius Block		Part Number: D2873-5
Inspection Dwg: D2873	Rev: A	Page 1 of 1

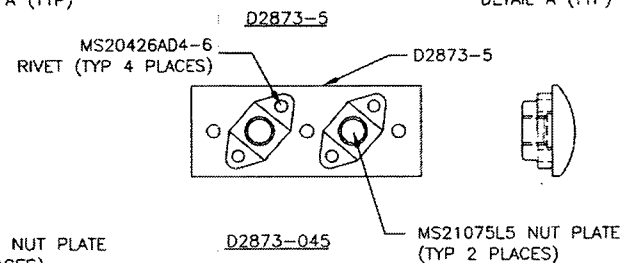
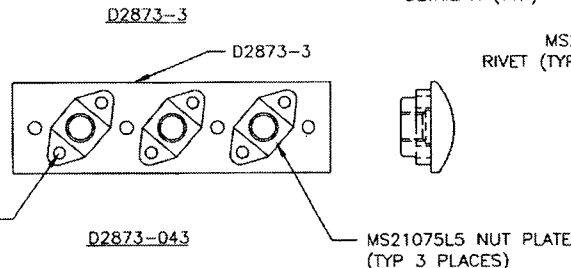
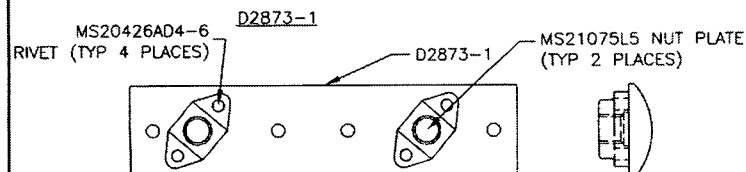
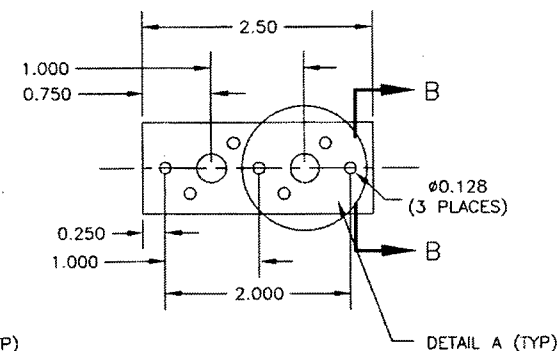
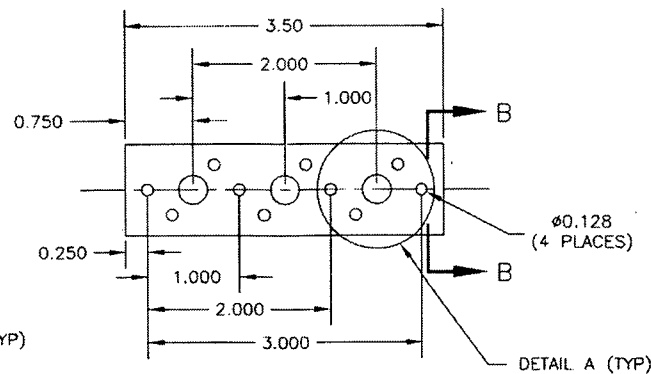
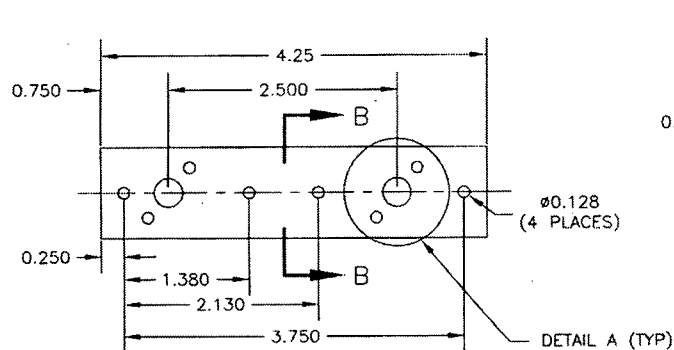
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	+/-0.030	2.500	✓		Vern	GA-01
1.000	+/-0.010	1.000	✓		"	"
0.750	+/-0.010	0.750	✓		"	"
0.250	+/-0.010	0.250	✓		"	"
1.000	+/-0.010	1.000	✓		"	"
2.000	+/-0.010	2.000	✓		"	"
Ø0.128	+0.005/-0.001	Ø0.133	✓		"	"
0.359	+/-0.010	0.359	✓		"	"
Ø0.316	+0.006/-0.001	Ø0.318	✓		"	"
1.000	+/-0.010	0.999	✓		"	"
0.250	+/-0.010	0.254	✓		"	"
0.061	+/-0.010	0.069	✓		"	"
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	Ø0.231 x 0.126	✓		"	"

Measured by: GA 08	Audited by: [Signature]	Prototype Approval: N/A
Date: 13/03/19	Date: 15-03-20	Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-045	KJ/JLM	[Signature]



D2873-1/-3/-5 RADIUS BLOCK

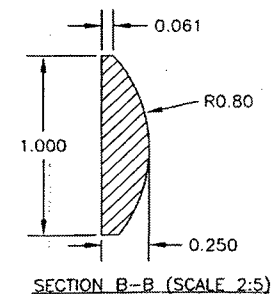
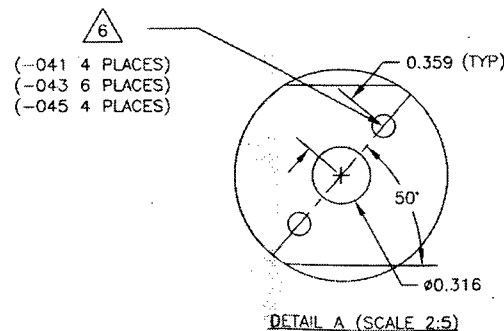
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X00.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100"

D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

	-041	-043	-045	PART NUMBER	DESCRIPTION
	X			D2873-041	NUT PLATE ASSEMBLY
		X		D2873-043	NUT PLATE ASSEMBLY
			X	D2873-045	NUT PLATE ASSEMBLY
1				D2873-1	RADIUS BLOCK
		1		D2873-3	RADIUS BLOCK
			1	D2873-5	RADIUS BLOCK
4	6	4		MS20426AD4-6	RIVET
2	3	2		MS21075L5	NUT PLATE



A	05.07.26	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED DS	APPROVED DS	DRAWING NO. D2873
DATE 05.07.26	TITLE RADIUS BLOCK	REV. A SHEET 1 OF 1 SCALE 4:5